

Date: Wednesday, 13/08/2008 12:40:17 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TUBE ASSEMBLY
<b>Job Number</b> :	41223		
<b>Estimate Number</b> :	13287		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3697041
<b>This Issue</b> :	13/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3697 REV B
<b>First Issue</b> :	13/08/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41021	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JULIE LECOCC</u> 08.8.13	<b>Due Date</b> :	29/08/2008
<b>Comment</b> :	Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec		

Qty: 6 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W049	6061-T6 RD Tube .375 x.049W
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Comment: Qty.: 6.3000 f(s)/Unit Total : 12.6000 f(s)  
 6061T6 aluminium tube OD 0.375" X 0.049" wall  
 (M6061T6T0.375W0.049)  
 Batch: M109000 X 36'

E2 9-3-9

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut at 6.00" as per dwg D3697

2- form and trim tube as per dwg D3697 using DT9003

3-deburr

E2 9-3-9

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

E2 9-3-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 12:40:17 PM  
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## Process Sheet

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Drawing Name: TUBE ASSEMBLY

Job Number: 41223

Part Number: D3697041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D37971

Ground Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Ground Plate

batch: B46321 X6

EL 9-3-9

6.0

D36973

Support Plate, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Plate, LH

batch: B40662 X6

EL 9-3-9

7.0

D36974

Support Plate, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Plate, RH

batch: B40663 X6

EL 9-3-9

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig

2-drill holes in tube in 5 pls as per dwg D3697 M104855

EL 9-3-10 X6

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-110

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

205-03-11(6)

X6

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

uma / BR

09/03/12 X6

1-Chemical Conversion Coat as per QSI 005 4.1

2-Mask hatched areas (5 pls) on both sides of ground plate only. Before powder coating.

105/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE ASSEMBLY

Job Number: 41223

Part Number: D3697041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

D 3690-041

B 4108

S/S 09/03/19

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19

Job Completion



u 09.03.19

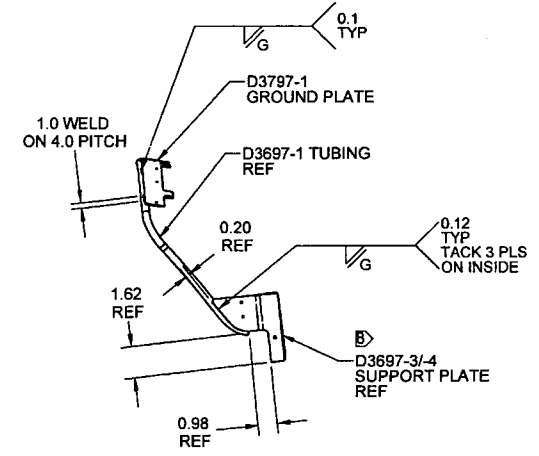
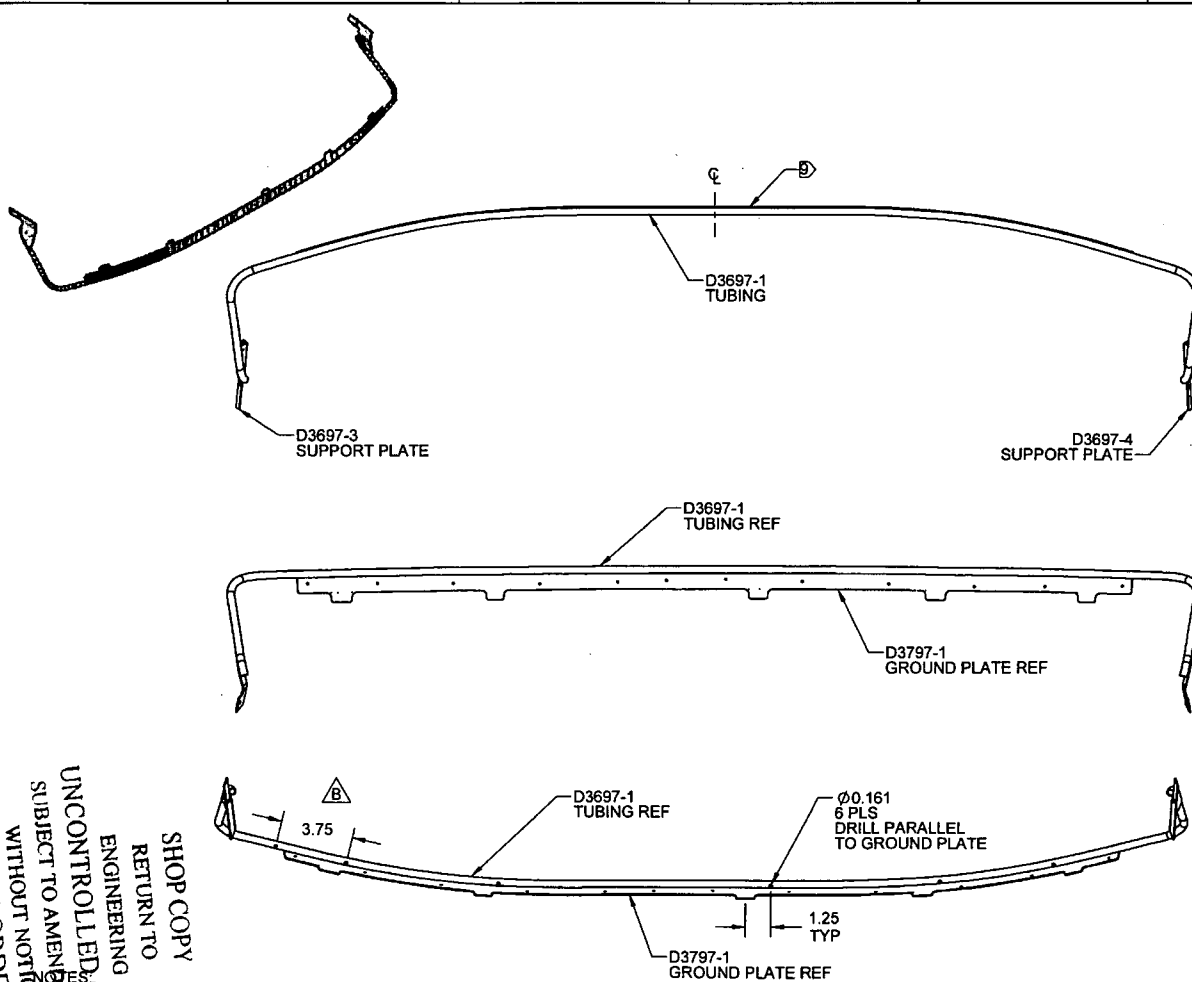
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
08-07-06

PART LIST

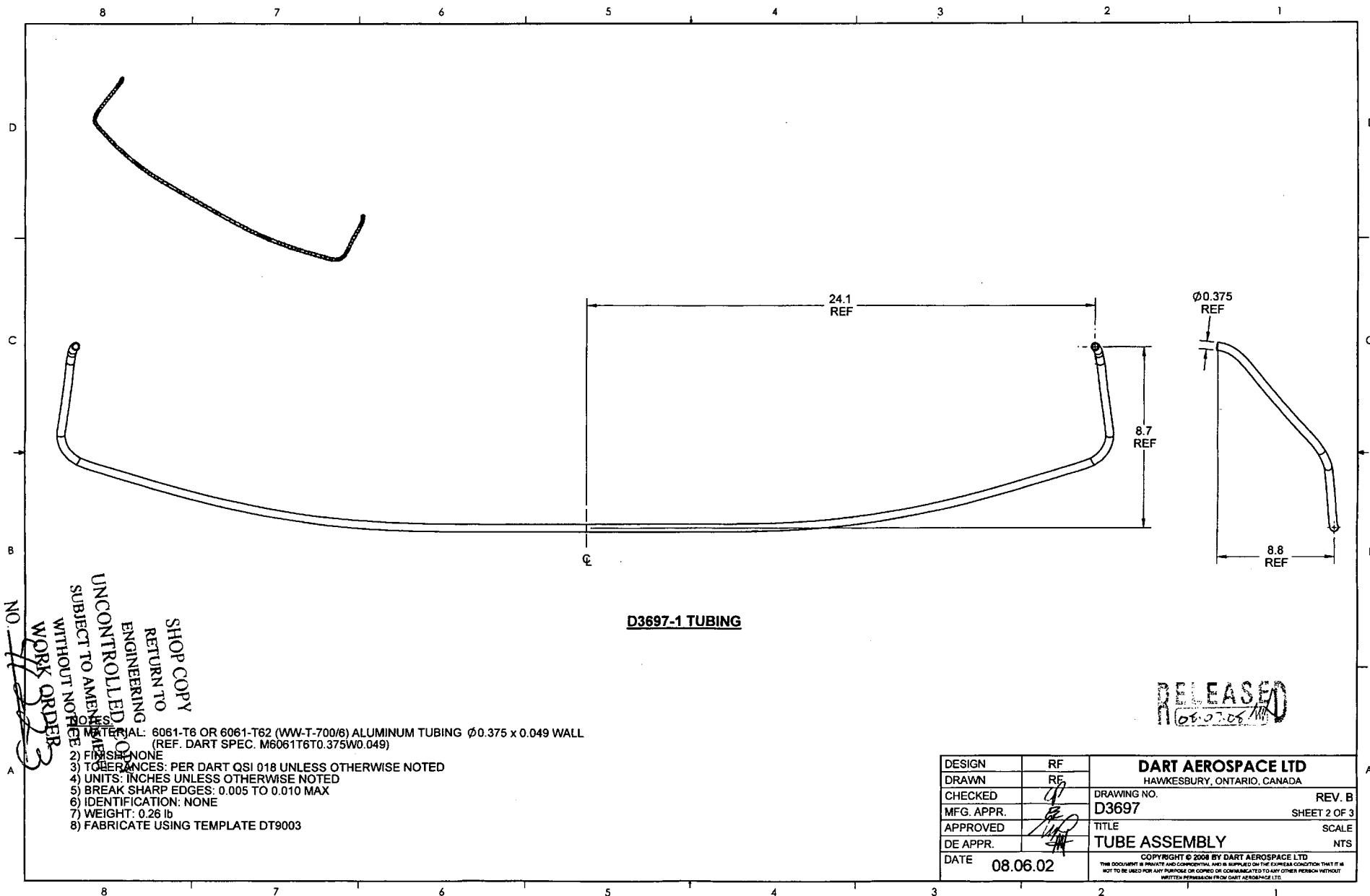
QTY	PART NUMBER	DESCRIPTION
-041		
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D3697	SHEET 1 OF 3
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	TUBE ASSEMBLY	NTS
DE APPR.	RF	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3697-041 TUBE ASSEMBLY

NO. 41003  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING



# **D3697-1 TUBING**

RELEASED  
08.06.02

NO. 11223  
WORK ORDER  
UNCONTROLLED  
ENGINEERING  
RETURN TO  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

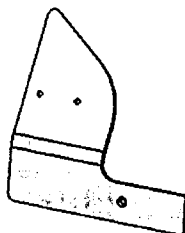
- MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING Ø0.375 x 0.049 WALL  
(REF. DART SPEC. M6061T6T0.375W0.049)
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 0.26 lb
  - 7) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3697</b>	REV. B
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>TUBE ASSEMBLY</b>	NTS
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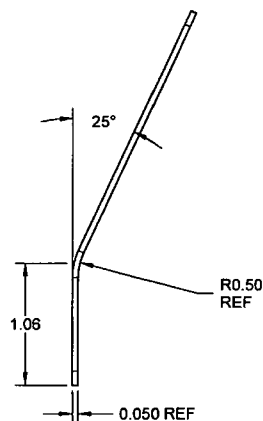
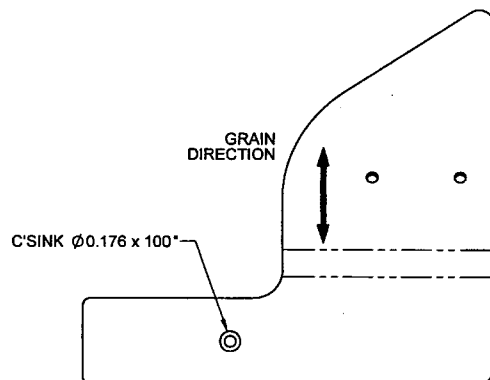




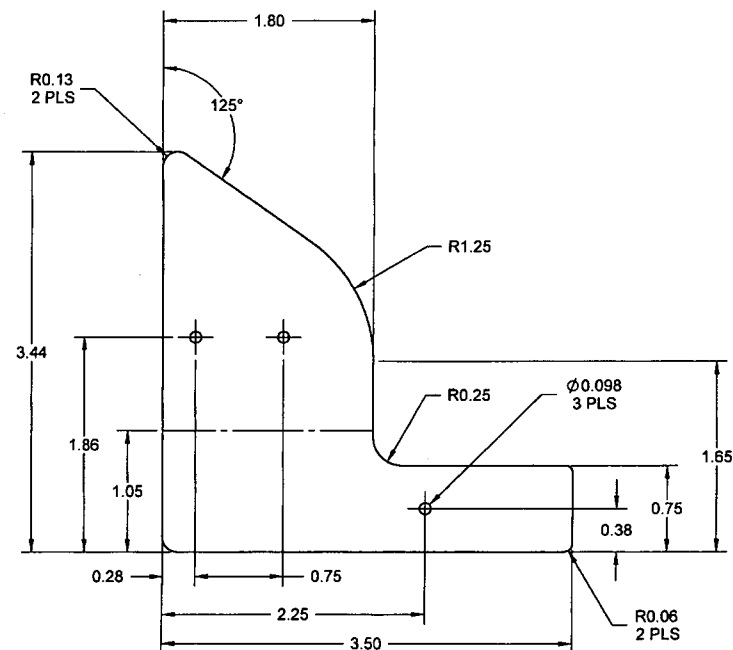
**D3697-3 SUPPORT PLATE (LH SHOWN)**



**D3697-4 SUPPORT PLATE (RH SHOWN)**







**D3697-3 SUPPORT PLATE (LH SHOWN)**  
**(D3697-4 SUPPORT PLATE OPPOSITE)**  
 (MAKE FROM D3697-3F FLAT PATTERN)



**D3697-3F FLAT PATTERN**

RELEASED  
 08-07-08

- NOTES:
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.03 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3697</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>TUBE ASSEMBLY</b>	NTS
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